

Date: Thursday, 17/08/2006 3:16:18 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RESTRICTOR FITTING
Job Number : 28208	
Estimate Number : 10928	
P.O. Number : <i>N/A</i>	Part Number : D2005013
This Issue : 17/08/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2005 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : C
Previous Run : 26884	Material : <i>N/A</i>
Written By : _____	Due Date : 15/09/2006 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. B99.08.24 Re-format DM/EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	AN8328J	Union, Bulkhead-M-Flare
-----	---------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Elbow, Bulkhead-M-Flare

Pick:

Qty	Part Number	Description	Batch
1	AN832-8J	fitting	<i>M101925</i>

*FF 06.09.01**5*

2.0	D2005003	Restrictor
-----	----------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Restrictor

Pick:

Qty	Part Number	Description	Batch
1	D2005-003	Restrictor	<i>B19073</i>

*FF 06.09.01**PTO**5*

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL / MED FAB

Machine elbow P/N: AN833-8J per Dwg. D2005-013

Press fit D2005-003 restrictor in place as per Dwg. D2005-013

Note: (15° chamfer towards inside of fitting)

Stake restrictor in place using clean ballpeanhammer to tap down edge.

Polish smooth finish


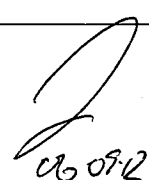

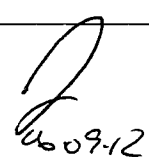
Scribe P/N: D2005-013

*FF 06.09.12**5**FF 06.09.12**5*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/09/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.09.12	3.0	1AN 832-8J Fitting hole for Restrictor too deep.	ASPER 05/09/12 04/09/12 	Destroy and Replace	06.09.12 EF	 06.09.12	ASPER 05/09/12 06.09.12 	 06.09.12

NOTE: Date & initial all entries

Date: Thursday, 17/08/2006 3:16:18 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RESTRICTOR FITTING

Job Number: 28208

Part Number: D2005013

Job Number:



Seq. #:

Machine Operation:

Description:

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/09/13 (5)

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST015

SB 06/09/14 (5)

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SB 06/09/14 (5)

Job Completion



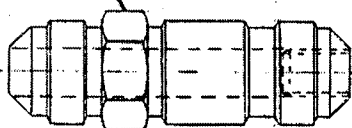
W 06/09/14



DESIGN BRADLEY	DRAWN BY BRADLEY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2005-013	REV C
DATE 96.04.17		TITLE RESTRICTOR B'HEAD FITG	SCALE
C		REDRAWN 96.04.17 BRADLEY	

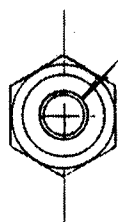
RELEASED
97/09/03 DS

AN 832 - 8J
FITTING



DRILL 11mm DIA
x .500 AS SHOWN

D 2005-003
FORCE FIT AS
SHOWN AND STAKE
IN PLACE.



DETAIL OF D2005-013.

SCALE 1:1

REFERENCE ONLY